Date: Tuesday, 1/2/2007 1:30:30 PM
User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 30097		
Estimate Number	: 10534		
P.O. Number	: N/A	**Part Number**	: D2574
This Issue	: 1/2/2007 **S.O. No.** : N/A	**Drawing Number**	: D2574 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 29663	**Material**	: N/A
Written By	:	**Due Date**	: 1/9/2007 **Qty:** ~~8~~ 12 **Um:** Each
Checked & Approved By	:		
Comment	: Est Rev: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: B25351 12 Er 07/01/09

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. B30097 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

Er / J.F. 07/01/18 (12)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

Er / J.F. 07/01/18 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes (No) **DQA:** _____ **Date:** 07/01/22

NOTE: Date & initial all entries

QA: N/C Closed: _____ **Date:** _____

Date: Tuesday, 1/2/2007 1:30:30 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 30097 **Part Number:** D2574

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ED / J.F. 07/01/18 (12)
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	SA 07.01.18
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	a.m 07/01/18 (12)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	M102391 FR/a.m 07/01/18 (12)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	PC 7/01/22 (12)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST467	PC 7/01/22 12
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/01/22 (12)

Job Completion CL 07/01/22

Form: rprocess

Dart Aerospace Ltd

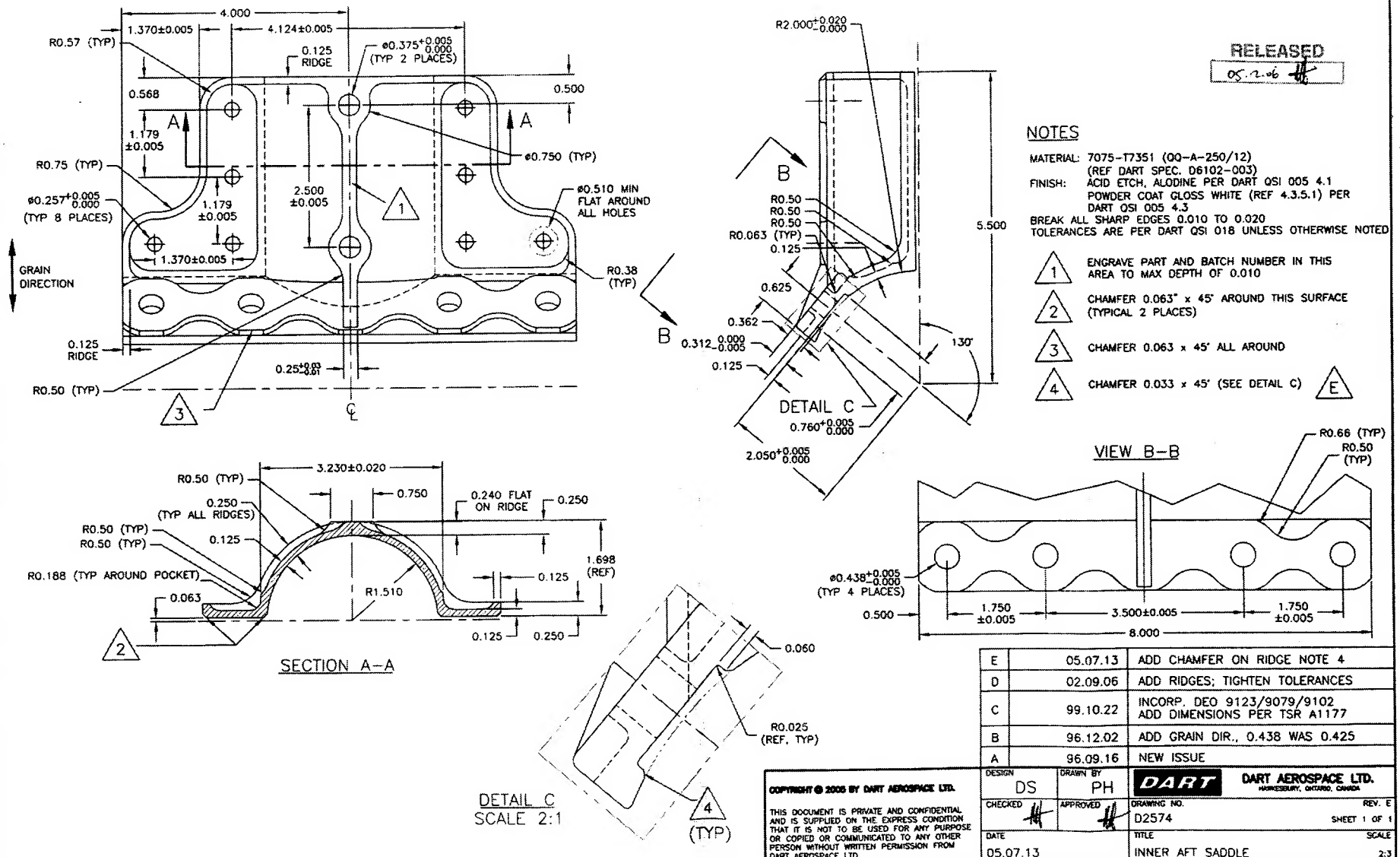
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Mfg / Design Mgr	**Approval** QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Design Mgr	**Approval** QC Inspector
			Initial Design Mgr	**Action Description** Design Mgr	**Sign & Date**			

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

TE: Date & initial all entries **QA: N/C Closed:** _____ **Date:** _____

Quality Assurance\approved forms\NCRWO revC



RELEASED
05.7.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD.
DS	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2574 REV. E
DATE 05.07.13		SHEET 1 OF 1
		TITLE INNER AFT SADDLE SCALE 2:3

CJ0710102
W/O 30097

DART AEROSPACE LTD	Work Order:	30097
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443	~~DT8682~~	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.747	1.748	1.748		
C	3.495	3.505		3.498	3.500	3.498	3.501		
D	1.745	1.755		1.749	1.747	1.748	1.748		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		0.498	0.491	0.496	0.494		
G	0.257	0.262	~~DT8683~~	0.260	0.260	0.260	0.260		
H	0.375	0.380	~~DT8684~~	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.495	0.499	0.495	0.500		
J	1.174	1.184		1.178	1.177	1.176	1.178		
K	0.558	0.578		0.567	0.565	0.564	0.567		
L	1.174	1.184		1.178	1.177	1.176	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.370		
N	2.495	2.505		2.497	2.500	2.498	2.500		
O	4.119	4.129		4.120	4.121	4.123	4.121		
P	0.115	0.135		0.125	0.125	0.125	0.124		
Q	0.115	0.135		0.135	0.125	0.135	0.135		
R	0.240	0.260		0.249	0.253	0.254	0.254		
S	0.115	0.135		0.122	0.120	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.227	3.230	3.230	3.230		
V	0.230	0.250		0.237	0.231	0.234	0.233		
W	0.115	0.135		0.125	0.121	0.121	0.121		
X	0.307	0.312		0.311	0.311	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.356	0.361	0.360	0.361		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.625	0.625	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.246	0.251	0.248		
AE	1.500	1.520		1.513	1.514	1.516	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.248	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	
Date:	07/01/13

Audited by	J.F.
Date:	07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30097
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443	~~DT8682~~	0.440	0.440	0.446	0.440		
B	1.745	1.755		1.747	1.749	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.745	1.750	1.750		
E	7.990	8.010		8.004	8.004	8.003	8.004		
F	0.490	0.510		0.492	0492	0.492	0492		
G	0.257	0.262	~~DT8683~~	0.260	0.260	0.260	0.260		
H	0.375	0.380	~~DT8684~~	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.502	0.503	0.500	0.500		
J	1.174	1.184		1.176	1.179	1.179	1.179		
K	0.558	0.578		0.568	0566	0.568	0.565		
L	1.174	1.184		1.176	1.179	1.179	1.179		
M	1.365	1.375		1.369	1.369	1.365	1.370		
N	2.495	2.505		2.498	2.498	2.500	2.500		
O	4.119	4.129		4.123	4.123	4.120	4.120		
P	0.115	0.135		0.125	0.124	0.125	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.253	0253	0.254	0255		
S	0.115	0.135		0.121	0.125	0.123	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0234	0235	0.235	0.234		
W	0.115	0.135		0.120	0.122	0.121	0.120		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.365	0.365	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.627	0.626	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0248	0.245	0.244		
AE	1.500	1.520		1.512	1.511	1.511	1.511		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0248	0.250	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP
Date:	07/01/14

Audited by	J.F.
Date:	07/01/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30097
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443	~~DT8682~~	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.756	1.750	1.758	1,752"		
C	3.495	3.505		3.500	3.500	3.500	3,500"		
D	1.745	1.755		1.750	1.750	1.750	1,752"		
E	7.990	8.010		8.003	8.002	8.003	8,000"		
F	0.490	0.510		0.493	0.493	0.495	,493"		
G	0.257	0.262	~~DT8683~~	0.260	0.260	0.260	0.260		
H	0.375	0.380	~~DT8684~~	0.378	0.378	0.378	0.378		
I	0.490	0.510		0.497	0.500	0.500	0,502"		
J	1.174	1.184		1.177	1.177	1.177	1,181"		
K	0.558	0.578		0.569	0.569	0.568	,569		
L	1.174	1.184		1.177	1.177	1.177	1,181		
M	1.365	1.375		1.369	1.369	1.369	1,372"		
N	2.495	2.505		2.506	2.500	2.500	2,500		
O	4.119	4.129		4.126	4.126	4.126	4,125"		
P	0.115	0.135		0.126	0.124	0.125	,125"		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.254	0.253	,255		
S	0.115	0.135		0.126	0.125	0.121	,123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.233	0.234	0.235	,238"		
W	0.115	0.135		0.126	0.124	0.124	,121		
X	0.307	0.312		0.311	0.311	0.311	,311"		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.366	0.366	,372"		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.626	0624	0.625	,629"		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.248	0.245	,253"		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.250	0.251	,253"		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	SD / SF
Date:	07/06/16

Audited by	SD
Date:	07.01.18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	